

Work Order ID 92852***92852***

Page 1

November-09-12 1:47:20 PM

Item ID: D3648-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Driveshaft Tunnel Assembly

Start Date: 11/08/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/19/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-11-12 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3648

Rev B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D36482- Seal mating surface and all gaps as per dwg
D3648 with Proseal 700 fire wall sealant batch: 123 727

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS
15
12-11-30FF
12-11-29FF
12-11-29

1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Driveshaft Tunnel Assembly

Start Date: 11/08/12 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 11/19/12 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: _____

0.00

130

Memo

PPD 86710

0.00

Packaging

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

Memo

0.00

QC

Quality Control

12/12/30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

November-09-12 1:47:20 PM

Page 1

Work Order ID: 92852

Parent Item: D3648-041

Parent Item Name: Driveshaft Tunnel Assembly

Start Date: 11/08/12

Required Date: 11/19/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-10-03 EC verified by: DD
IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC
IPP Rev:C ECN1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A Bolt		Purchased	No			110	Each	325.0000	40	40		FF 12-11-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		38							
				118352		38							
				ST350		287							
				120187		1							
				123203		286				40			
D3649-041 Tunnel Bottom Panel Assembly		Manufactured	No			110	Each	1.0000	1	1		FF 12-11-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST190		1							
				90387		1				1			
D3650-041 Tunnel Top Panel Assembly		Manufactured	No			110	Each	1.0000	1	1		FF 12-11-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	92868	1				1			
				87686		1							
D3651-041 Aft Base Assembly		Manufactured	No			110	Each	0.0000	1	1		FF 12-11-29	
NAS1149C0363R Washer		Purchased	No			100	Each	4,286.0000	40	40		FF 12-11-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				297		2000							
				122441		2000							
				ST297		2286							
				114742		2086				40			
				122063		200							

NCR: Yes / No

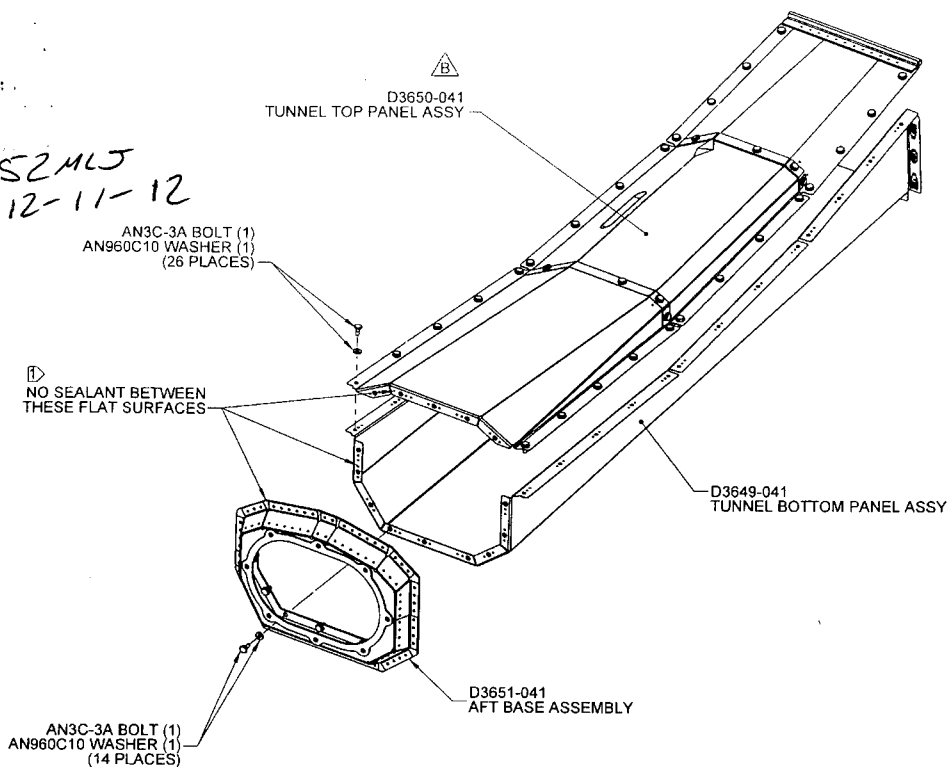
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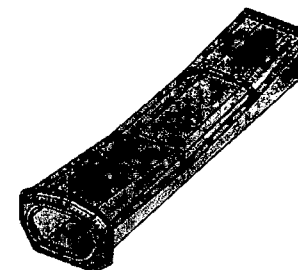
SHOW COPY
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO WORK
WITHOUT
WORK
NO. 92852MLJ
12-11-12



D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

NOTES:

- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED
08-03-27/12

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D3648	
CHECKED	RF	REV. B	
MFG. APPR.	RF	SHEET 1 OF 1	
APPROVED	RF	TITLE	
DE APPR.	RF	SCALE	
DATE	08.01.07	DRIVE SHAFT TUNNEL ASSY 1:6	

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